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(54) METHOD FOR ROLLING SHEET MATERIAL

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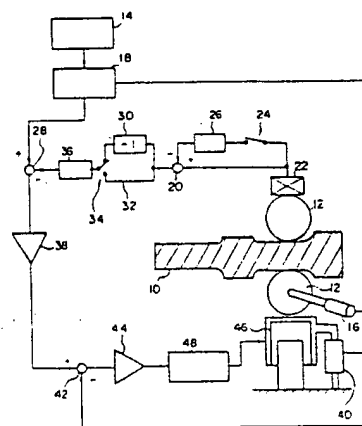
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PURPOSE: To exactly obtain a sheet material having a desired thickness difference and thickness distribution by adding the calculated change in the thickness to a set thickness to calculate a control thickness and rolling the sheet material while changing a roll gap according to the control thickness.

CONSTITUTION: The set thickness value and the difference in the change component of the thickness outputted from a roll gap setter 18 is calculated in a 2nd subtractor 28 and is outputted to a 1st controller 38. The output of the controller 38 is inputted as the set value of the roll gap to the 3rd subtractor 42, by which the difference from the actually measured roll gap detected by a roll position sensor 40 is calculated. The calculated difference is inputted to the 2nd controller 44. The controller 44 controls the driving of a servo valve 48 by computation and the valve 48 controls the volume of the oil to be supplied to a lifting cylinder 46, thereby changing the position of the lifting cylinder 46 and eventually the rolling down position of rolling rolls until the change component in the thickness outputted from a coeff. device 36 is negated. The flatness of the thin part is thus assured.



10: slab, 12: rolling roll, 14: calculator, 16: pulse generator, 20: 2nd subtractor, 22: load cell, 26: memory, 30: code inverter, 32: bypass circuit, 34: selector switch

入側板厚が
トンとなり、
以降におい
すること
る鋼板が切
、鋼板は肉
厚となった。

に示され
厚部が2.0
た。この厚
で1枚の板
となる度毎
32個に切
する際、所
)まで圧延
34を符号
品板材の寸
肉厚部の長
000mm、

他の板厚
である。

、所望の厚
度と且つ比
の板材の

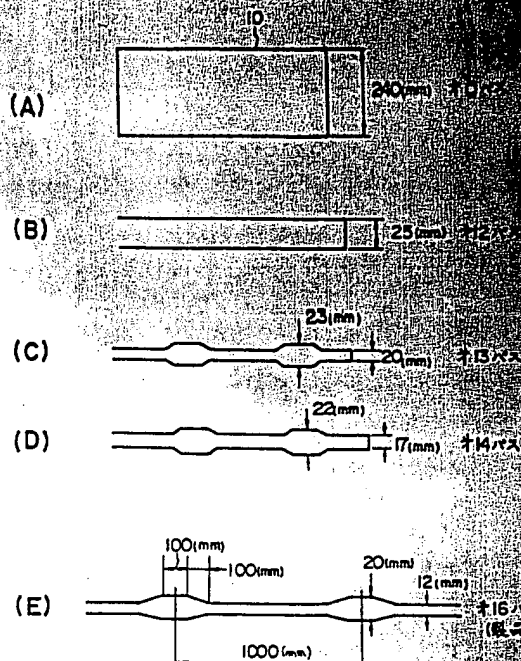
制御装置の
ブロック線図、
る板材の
面図である。

り減算器、
F、

- 30 ... 符号反転器、
- 32 ... バイパス回路、
- 34 ... 切替えスイッチ、
- 36 ... 係数器、
- 38、44 ... 第1、第2のコントローラ、
- 40 ... ロール位置センサ、
- 46 ... 押上げシリンダ、
- 48 ... サーボバルブ。

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第 2 図



第 1 図

